

SPLIT

split

Date: Thursday, 24/07/2008 3:13:55 PM
Use: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206-558-041
Job Number : 40748-5 Estimate Number : 10804
P.O. Number : Part Number : D206558041
This Issue : 24/07/2008 S.O. No. : Drawing Number : ECN08-504
Prsht Rev. : NC Project Number :
First Issue : 11 Type : SMALL /MED FAB Drawing Revision :
Previous Run : 00015 Material :
Written By : Due Date : 05/08/2008 Qty: 18 Um: Each
Checked & Approved By :
Comment :

SPLIT 6

split

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
3X D206-558-041 B 385800 ✓ FFx3 08-07-30
PULL FROM STOCK:
3 X D206-558-041 B39281
10 X D206-558-041 B39398 ✓ FFx10 08-07-30
5 X D206-558-041 B39399 ✓ FFx5 08-07-30

2.0	D206558041	Single Cargo Mirror Assembly
-----	------------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)
Single Cargo Mirror Assembly

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS
D2011-101 MIRROR
D2052 MTG BRKT
D2054 BUSHING
D2055 CLAMP
D2056 BELL CRANK
D2057 PLUG
PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

SWAP

FF 08-07-30

DISCARD HARDWARE

FF 08-07-30

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

Thursday, 24/07/2008 3:13:55 PM

Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-041

Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #: Machine Or Operation: Description :

4.0 M304TR0500W049 304 RD Tube .500 x .049W



Comment: Qty.: 1.7500 f(s)/Unit Total: 31.5006 f(s)
304 RD Tube .500 x .049W per EN 08-504 n
304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012
(M04TR0.500W049)
Identify as D2065.
Note: 1 end only

Batch

108324

M 108324
M 108323
FF 08-07-31

(5)
(3)
(10)

take 10x D2065 from B 40580

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Punch 1/2" OD x .035" Wall AISI

Signed for SR.

FF

08-07-31 - (10)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Cut to length as per Dwg D2065
Bend as per Dwg D2065 and template D2065T1
Flatten the end on Hydraulic press using Dt 8545
Drill 00.188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig.
Deburr.

FF 08-07-31

FF 08/09/15 10

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soclosis (10)

Soclosis (10)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

102316

(10x)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320
11:30

M-H

08/07/31

M 102316

START Time: 9:25 AM

Temp: 320°F

FINISH 9:55 AM

08-09-15 (10)

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-041

Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



M-1

08/04/15



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



P40

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D206-558

USING ORIGINAL COMPONENTS
AND NEW HARDWARE:

SB 08/10/10
FF 08-08-01

11.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 72.0000 Each(s)
Washer

Pick:

Qty Part Number

Description

Batch

4 AN960JD10

Washer

M109059
M100550

FF 08/10/09

FF 08-08-01

12.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 26.0000 Each(s)
Nut

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut

or MS21042-3

M100701
M107665

FF 08/10/09

FF 08-08-01

13.0 MS27039118 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 36.0000 Each(s)
Screw

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-18

Screw

M1007161
M1007161

FF 08/10/09

FF 08-08-01

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/10

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-558-041

Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR
ORIGINAL KITS TO BE INCLUDED.

8 08/10/14

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP
USING NEW B/N @ CHG 007
NEW LABELS REQUIRED
ADD PAPERWORK DSI 9416

11 12/8/14 6

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/15







Job Completion



11 08.10.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/08	70	5 Plugs (02057) B40040 820/08		FF 08/10/08			

Part No: D206-558-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: <u>40748-5</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/08	# 10.0	During Disassembly the 02057 Plugs were not saveable Due to the inside Decal the tubing chaging		Scrap all Plugs with Arms and Decal Pull from stock B# B40040	08/07/08 FF	 08/07/08 FF		 08/07/08
				B# B40040		 08/10/08		 08/10/08

NOTE: Date & initial all entries

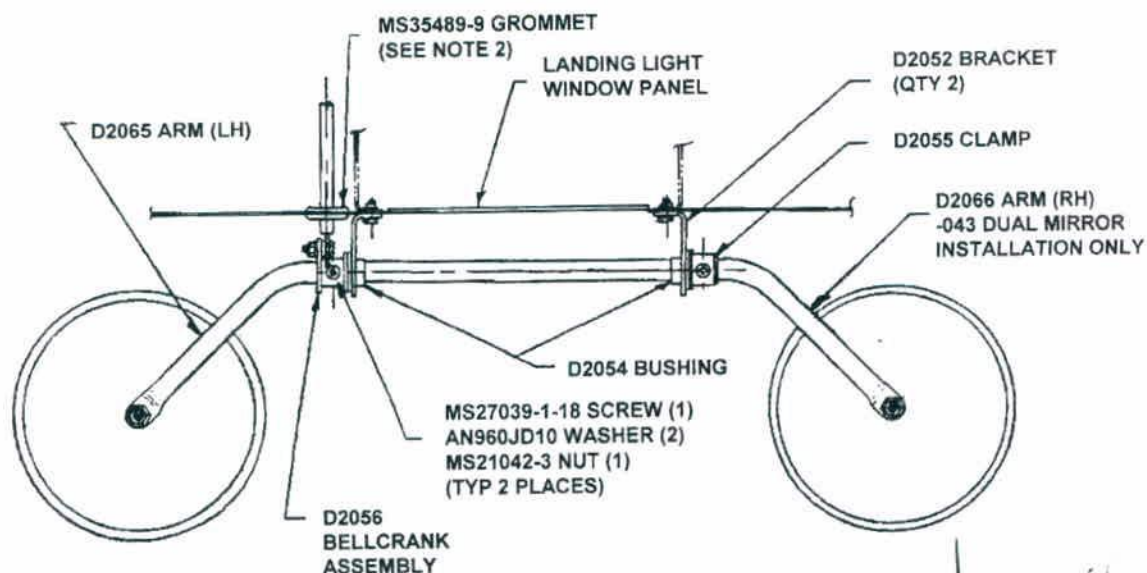


Figure 25.2 – View A: Looking Aft.
(D206-558-043 Mirror Shown)

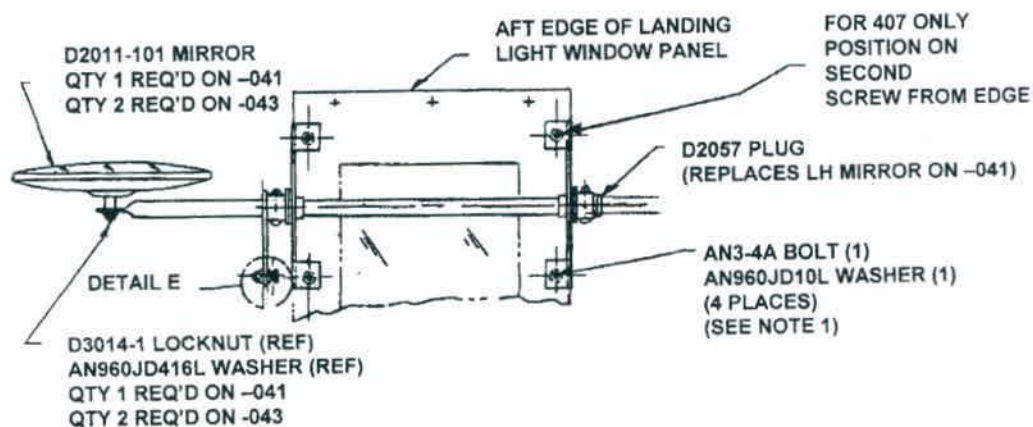


Figure 25.3 – View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

• COPYRIGHT © 2001 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00